| DESIGN | DRAWN BY | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA | |
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| CHECKED | APPROVED | DRAWING NO. | REV. A |
| | | DSI 9306 | SHEET 1 OF 2 |
| DATE | | TITLE | SCALE |
| 05.06.27 | | D412-705-015 INSTALL MOD | NTS |
| A | 05.06.27 | NEW ISSUE | |

# DART SERVICE INSTRUCTION

**TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-705 REV. A OR B**

REF. CANADIAN STC: SH04-25

REF. FAA STC: ST01994NY

TO MAKE DART D412-705-015 DRIVE SHAFT TUNNEL MODIFICATION KIT COMPATIBLE WITH BELL P/N 212-061-903-177/-199 UPPER WEB ASS'Y, MODIFY THE INSTALLATION PROCEDURE AS SHOWN BELOW:

1) Remove P/N 212-061-903-177/-199 Drive Shaft Tunnel (Centerline Firewall) I.A.W. BHT-212 (412)-MM.

2) Position D3256-041 Access Panel Assembly inside Drive Shaft Tunnel as shown in Figure 1, with Tang facing aft in the bottom of the tunnel, ensuring that the panel follows the contours of the tunnel. The Aft edge of the untrimmed D3256-041 Access Panel should be 10.5" (266 mm) from the Aft end of the Drive Shaft Tunnel, or 9.88" (251 mm) from the Tang to the Aft edge. Mark the Drive Shaft Tunnel with the outline of the untrimmed Access Panel.

   ***Note: The Aft edge of the D3256-041 Access Panel will need to be trimmed to fit the P/N 212-061-903-177/-199 Tunnel and P/N 212-061-903-009 Cover Assembly. Do not transfer aft holes from Access Panel to Tunnel.***

3) Remove the row of rivets attaching the P/N 212-061-903-009 Cover Assembly to the P/N 212-061-903-177/-199 Drive Shaft Tunnel inside of the marked area made in step 2.

4) Clamp D3256-041 Panel into Drive Shaft Tunnel ensuring seal contact around entire perimeter of access panel. Transfer the 10 holes from forward edge of the D3256-041 Access Panel Assembly and 2 top holes of the Access Panel to Drive Shaft Tunnel P/N 212-061-903-177/-199 with a #40 drill. ***Note: do not transfer the aft holes from the Access Panel.*** Match drill the 2 bottom holes from the Tunnel to the Access Panel.

5) Match drill from the Tunnel/Cover Assembly to the Access Panel, 10 holes through the existing empty rivet holes with a hole spacing pattern which most closely matches the forward Access Panel hole pattern.

6) Remove gasket from Aft end of Access Panel and trim approximately 0.44" (11.1 mm) from the Aft edge of the Access Panel. ***Note: Ensure minimum edge distance of 0.300" (7.6 mm).*** Reinstall the gasket over the new Panel edge and holes drilled in step 5.

7) Cut out two rectangular sections of the P/N 212-061-903-177/-199 Drive Shaft Tunnel, as shown in Figure 1, Detail A. ***Note: No part of P/N 212-061-903-009 Cover Assembly is Cut.*** Leave the center bottom section of the P/N 212-061-903-177/-199 Tunnel as shown in Detail A. Ensure cut out will leave a minimum edge distance of 0.30" (7.6 mm) from center of each hole to cut edge. Deburr the cut out. Dimple remaining rivet holes not used in step 5. Install MS20427M3 rivets where center bottom section of the P/N 212-061-903-177/-199 Tunnel attaches to the P/N 212-061-903-009 Cover Assembly.

CANADA
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DAO # 01-O-01

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D. SHEPHERD (DE # 02)

DATE: 05.06.27
CERT. NO.: SH04-25
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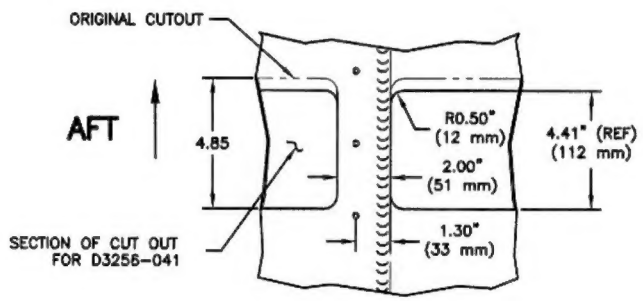
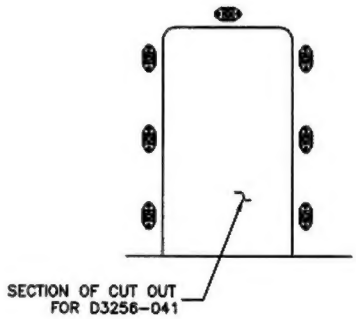
8) Upsize the holes used for step 5 to Ø0.204" (Ø5.18 mm) on Access Panel and P/N 212-061-903-009 Cover Assembly for clearance size on AN3 bolts. Install MS21060-L3K nut plates (22 places) using MS20427M3-3 rivets (use #40 drill 44 places) as shown in Figure 1.

9) Install D3256-041 Access Panel Assembly into Drive Shaft Tunnel using AN3C bolts provided. Use AN3C-3A bolts on the sidewalls and AN3C-4A bolts (2 places) on the bottom center locations. Ensure good fit between the Access Panel Assembly and the Drive Shaft Tunnel. Torque bolts to a maximum torque 25 in-lb (3 Nm).

10) Re-install modified Drive Shaft Tunnel I.A.W. B.H.T.-212 (412)-MM




DETAIL A
VIEW FROM BOTTOM




DETAIL B
SIDE VIEW

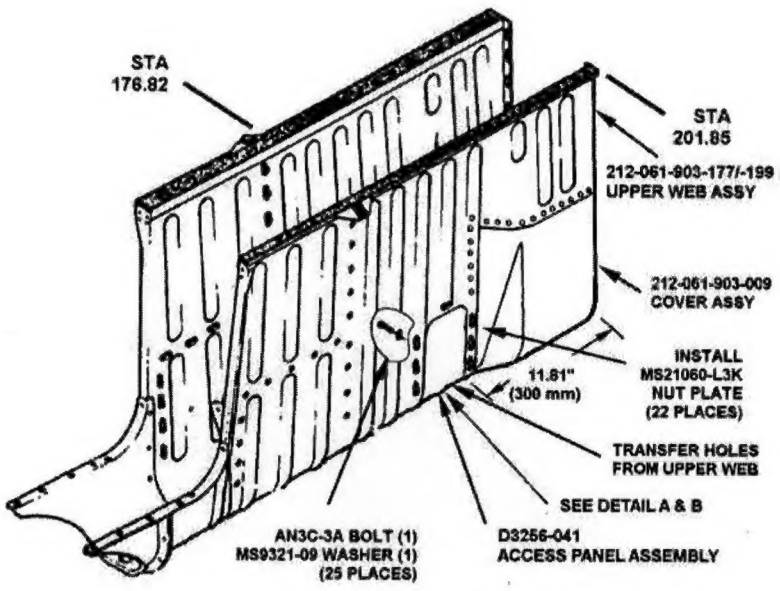



**Figure 1**

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